



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5738-041
Job Sheet 203347

Accounting Job RD19-1069-01



Part No: D5738-041

Job Qty: 2 pcs

Part Name: FWD Wearbar Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5738 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/11/19 AUTH *MD*

RELEASED 9 DATE 19-11-19

Priority: Medium

OK to release

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	2 pcs	11/29/19	11/29/19	0.00	0.08	Large Fab - 1		<i>MD</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		<i>MD</i>
110	Automated Welding - B4B	2 pcs	11/29/19	11/29/19	0.00	1.56	Automated Welding - 1 - B4B		
120	QC 10	2 pcs	11/29/19	11/29/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		<i>MD</i>
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
			11/29/19	11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



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Container No: S235135



Part: D5738-041

Job No: 203347

Serial No/Batch: S235135

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/27/19

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	2 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	2 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	



DAS

9

9-89

19-11-28

DAS

21

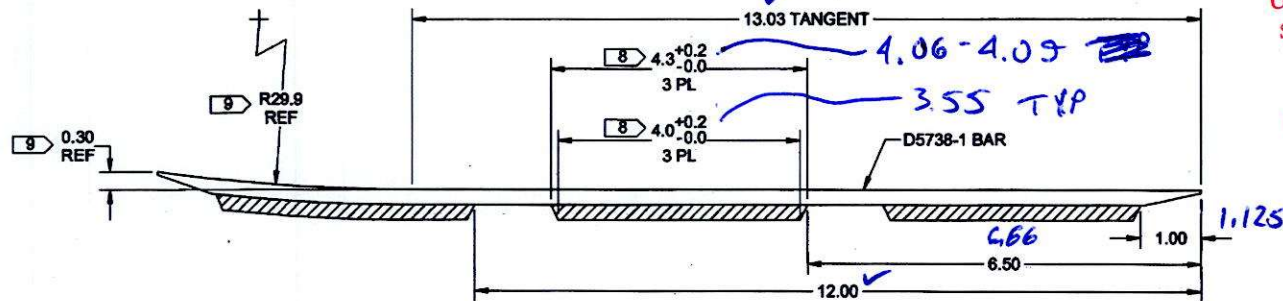
NOV 29 2019

Part Op 100 - (Large Fab) Cut D5738-1 at 18.75" (EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D5738-041)
 Descriptions: 110 - (Automated welding) 1-USE GRINDER TO CHAMFER END AS PER DWG. ***SEE NOTE 8 FOR SURFACE BUILDUP*** USE DT _____ WELDING FIXTURE 8259 - M139025
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: 44001) LOCATION: WA002
 150 - (QC21- Final Inspection - Work Order Release)

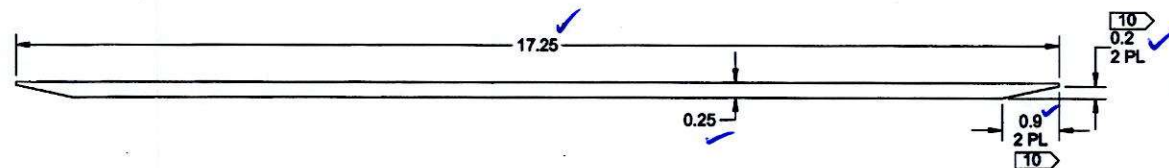
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	3.1400 ft (1.57 ea)	100-Large Fab - Welded Assy-1	5227407
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	3	618	0
Part Specifications				
Specifications could not be found.				

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WITHOUT NOTICE
WORK ORDER
NO. 203347 MW
1971-15



D5738-041 FWD WEARBAR ASSY



D5738-1 BAR

NOTES:

- 1) MATERIAL: MAKE D5738-1 FROM AISI 304/316 SS BAR, 0.25 THICK X 0.50 WIDE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.03 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER DART QSI 004 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER DART QSI 004 4.1 (MANUAL WELDING)
- 9) FORM TO MATCH PROFILE OF D5737-1 WEARPLATE
- 10) GRIND CHAMFER 0.9 X 0.2

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

APPROVED

A	NEW ISSUE		ZF	19.08.23
REV.	DESCRIPTION		BY	DATE
DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR		
DRAWN	ZF			
CHECKED	MW		DRAWING NO.	REV. A
MFG. APPR.	DD		D5738	SHEET 1 OF 3
APPROVED	NO		TITLE	SCALE
DE APPR.	DS		WEARBARS	NTS
DATE	19.08.23		COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : 19.12.05	Sequence #: 130	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		NO 19.12.11	
weld size not to drawing. should be $\rightarrow 4.3" \pm .000$ is 4.06" $\rightarrow 4.0" \pm .000$ is 3.55"		welds acceptable as is dwg tolerances will be revised to match achievable manufacturing tolerance		Completed By NO 19.12.11	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details:			

